

Date: Thursday, 2/14/2008 10:57:45 AM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	PATIENT STOP		
Job Number	37434					
Estimate Number	11490					
P.O. Number			Part Number	D2492		
This Issue	2/14/2008	S.O. No.	Drawing Number	D2492 REV F		
Prsht Rev.	NC		Project Number	N/A		
First Issue	/ /	Type	Drawing Revision	F		
Previous Run	36243		Material			
Written By			Due Date	2/25/2008	Qty:	10
Checked & Approved By	<u>JA 080214</u>		Um:	Each		
Comment	Est. E 00-06-26 Removed P/O for powder coat EC Est Rev:F Now 6061-T6 06-06-23 JLM Est Rev:G now water jet 07-12-11 DD					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6S080	6061-T6 .080 Sheet	
		Comment: Qty.: 1.9140 sf(s)/Unit Total : 19.1405 sf(s) 6061-T6 .080 Sheet Material: 6061-T6 0.080" thick (M6061T62S.080) Batch <u>107276</u> <u>BR 8-3-S</u>	 <u>10</u>
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D2492 Dwg Rev: <u>F</u> <u>BR 8-3-S</u> Prog Rev: <u>F</u>	
		2-Deburr if necessary <u>BR 8-3-S</u>	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	<u>08/08/08 (AO)</u>

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/14/2008 10:57:46 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PATIENT STOP

Job Number: 37434

Part Number: D2492

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Deburr

Form using Jig DT2492B

SAD 08/10/27 10

6.0 QC5 INSPECT WORK TO CURRENT STEP.



Comment: INSPECT WORK TO CURRENT STEP

SAD 08/10/27 X(10)

7.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



(10X)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

JM/M-1 08/10/28

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



SH

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-10-29

X(10)

9.0 POWDER COATING POWDER COATING



M109152

(10X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m-1 08/10/30

10.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



(10)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FZ 08/10/30

11.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: PIP Y1338

Re 08/10/30 (C)

12.0 QC21 FINAL INSPECTION/W/O RELEASE



08/11/03 FZ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-10-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

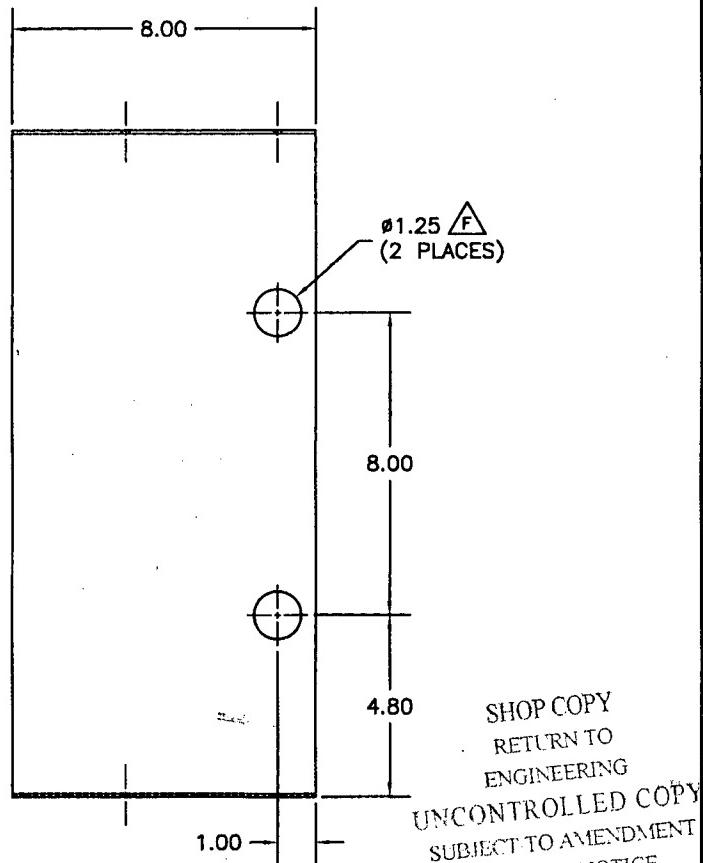
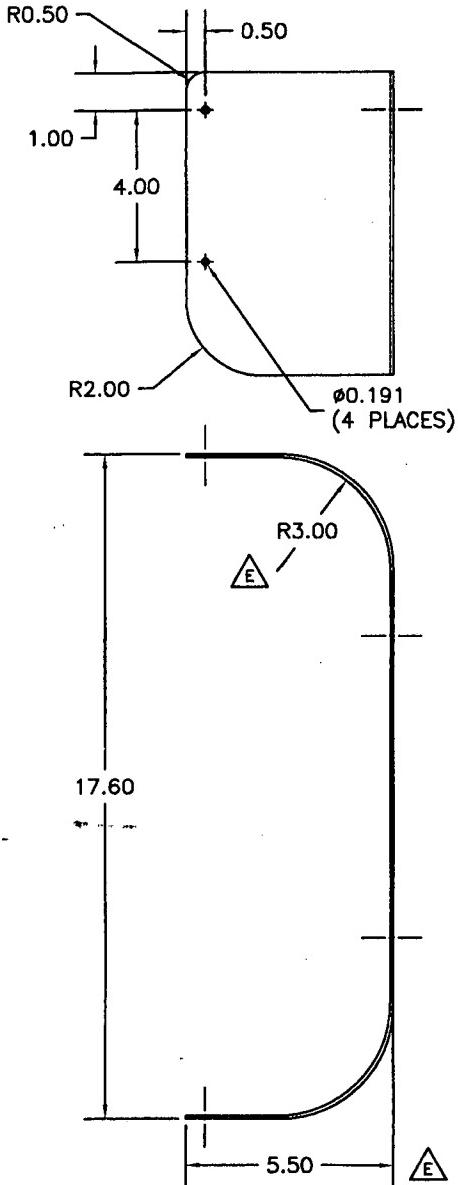
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN KE	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2492
DATE 06.09.14	TITLE PATIENT STOP	REV. F SHEET 1 OF 1 SCALE 1:5
A	95.10.24	NEW ISSUE
B	96.02.28	MINOR CHANGES
C	97.07.14	CHANGED MATERIAL AND FINISH
D	98.05.11	R4.00 WAS R2.00 ADDED 8" WIDTH DIMENSION
E	06.05.30	ADD 6061-T6 MATERIAL, R3.0 WAS R4.00, 5.50 WAS 6.00
F	06.09.14	Ø1.25 WAS Ø1.020



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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 37434

#### D2492 PATIENT STOP

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK  
(REF DART SPEC M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

RELEASED

06.09.14 *[Signature]*

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DART AEROSPACE LTD	Work Order:	37434
Description: PATIENT STOP	Part Number:	D2492
Inspection Dwg: D2492 Rev: F		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:	BB	Audited by:		Prototype Approval:	/
Date:	8-3-5	Date:	08/03/05	Date:	/

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	